

Work Order ID 56562

Monday, March 01, 2010 2:54:49 PM



Page 1

Item ID: D3815-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Web Assembly

Start Date: 3/2/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-3-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3815

Rev A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ES 10/03/16 (12)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- install rivets as per dwg D3815

ES 10/03/17 (12)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 6314

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: 2:30pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:00pm

0.00

⇒ 10/03/17

(12) ✓

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10-3-17

(12) ✓

150



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1- install screws loose (4 places) as per dwg D3815

10/03/18 (12)

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Required Date: 3/15/2010 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/11

412

170



Packaging

Packaging

Identify as per dwg & Stock Location: 203

0.00

Memo

0.00

10/3/22 12

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24

MF

10-3-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 2:54:48 PM

Page 1

Work Order ID: 56562

Parent Item: D3815-041

Parent Item Name: Web Assembly

Comments: IPP Rev:A 08-09-18 new issue DD verified by:EC

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3815-1



Angle

D3815-2



Angle

Manufactured

No

110

Each

0.0000

12.0000

B56776 (12)



EP 10/03/16

Manufactured

No

110

Each

2.0000

12.0000



EP 10/03/16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

53896

2

110

Each

7.0000

12.0000



2

D3815-3



Web

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

52928

7

110

Each

2,670.000

300.0000



EP 10/03/16

B56778 (500) ?

7

MS20470AD4-6



Rivet, Universal Head

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2670

113644

2670

EP 10/03/16

300

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Page 2

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Parent Item Name: Web Assembly


Comments: IPP Rev:A 08-09-18 new issue DD verified by:EC

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R14  Screw		Purchased	No			150	Each	879.0000	48.0000			

 *Ep 10/03/18*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

879

104916

879

150

Each

682.0000

48.0000



48

Ep 10/03/18

MS21042L08



Nut

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

682

110002

24

111889

30

112243

43

112492

24

112612

1

112794

8

113595

29

113749

323

114056

200

48

Monday, March 01, 2010 2:54:49 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149DN832J  WASHER		Purchased	No			150	Each	133.0000	48.0000			

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

111193

133

111359

3

114056

30

100

450/03/18

48

Monday, March 01, 2010 2:54:49 PM

Shop Packet Print

Page 3

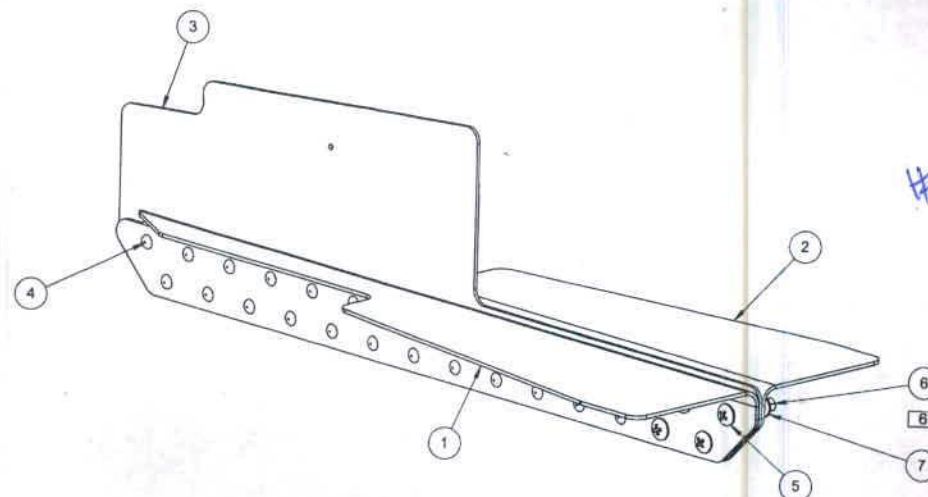
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	1
5	AN526C832R14	SCREW	25
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

RELEASED
09/03/10

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.22			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3815	REV. A
TITLE WEB	SHEET 1 OF 5
SCALE NTS	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

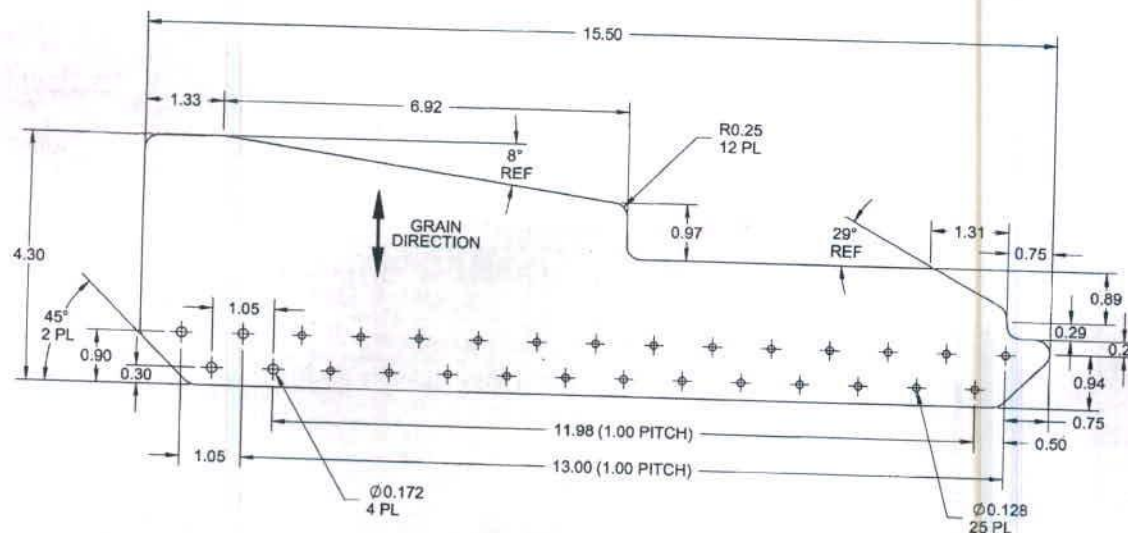
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#56560



D3815-1F FLAT PATTERN

RELEASED
07/01/13

NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.29 lbs

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MFG. APPR.		D3815	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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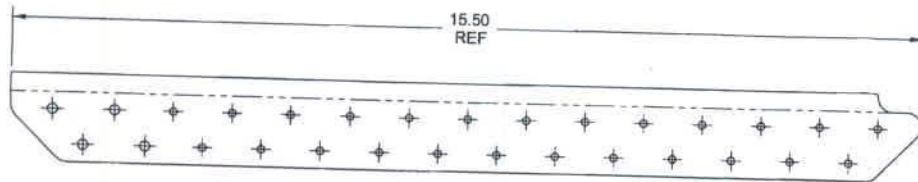
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

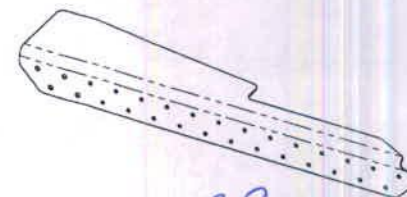
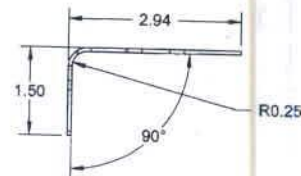
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

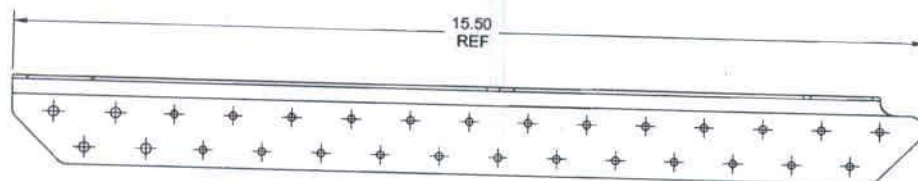
NOTE: Date & initial all entries



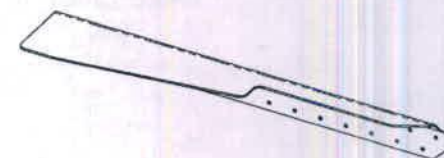
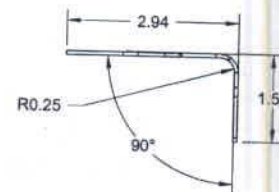
D3815-1 ANGLE
(MADE FROM D3815-1F)



#56567



D3815-2 ANGLE
(MADE FROM D3815-1F)



RELEASED
09/01/13

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MFG. APPR.		TITLE WEB	SHEET 3 OF 5
APPROVED		SCALE	NTS
DE APPR.		DATE 08.09.22	
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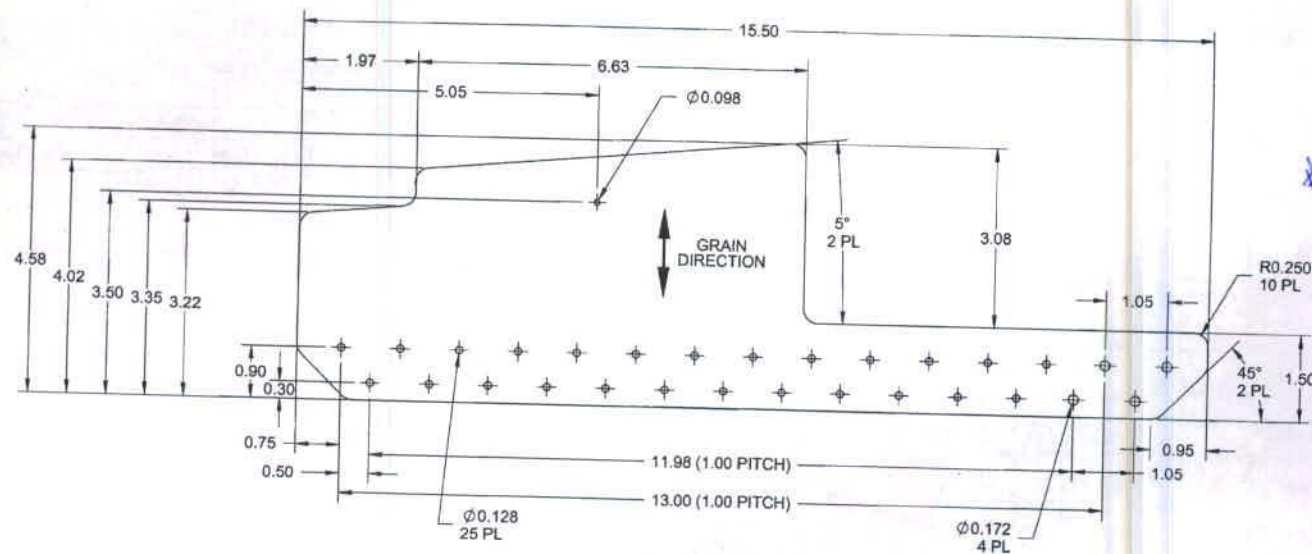
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3815-3 WEB

NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.28 lbs

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MFG. APPR.		D3815	SHEET 4 OF 5
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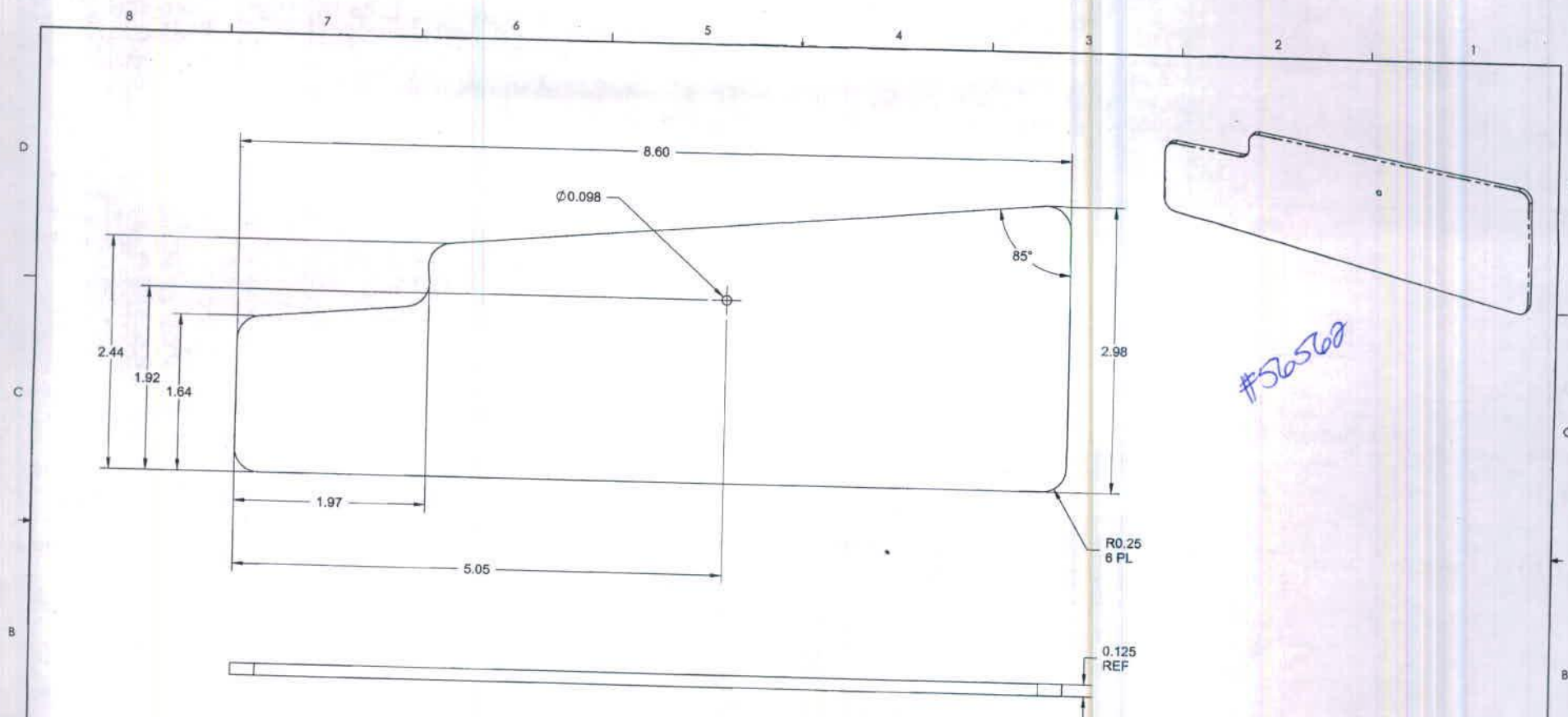
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3815-5 PACKER

RELEASED
07/01/13

NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D3815	SHEET 5 OF 5
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